

Work Order ID 131582

Thursday, April 16, 2015 9:16:31 AM

131582

Page 1

Item ID: D350-567-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***Item Name: ⁰⁴⁰Replacement WindowStart Date: ⁴⁰⁰4/16/2015 Start Qty: 1.00***1***

Cust Item ID:

Required Date: 4/16/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*Date: *15-04-16* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D350-567	E
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100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD350-567-023

CHG002

DAS
27
9-89DAS
6
9-89

JUN 25 2015

MLJ 15-06-22

110

Packaging

0.00

110

Packaging

Memo

0.00

Packaging

Pick Packing Kit

ENSURE DT 8439 TEMPLATE IS INCLUDED

*IX*DAS
27
JUN 22 2015DAS
26
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
6
9-89

JUN 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																					

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Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Window

Start Date: 4/16/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/16/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-023								
	Location: _____								
	PPP Rev: _____								
		132961							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
16
8-88

JUN 2 5 2015

MLJ JUN 2 5 2015

MLJ JUN 2 5 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Picklist Print

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Page 1

Work Order ID: 131582

Parent Item: D350-567-023

Parent Item Name: Replacement Window

131582

D350-567-023

Start Date: 4/16/2015

Required Date: 4/16/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-06-07 JLM
IPP Rev:B 08-10-07 as per revD DD verified by:
13.10.15 AS PER IIN REV.E DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-5

Purchased

No

Each

5,511.000

18

**

DAS
27
9-89

DAS
26
9-89

MS20426AD3-5

Rivet

DAS
18
9-89

Location

Loc Qty

Loc Code

GA

4307

4533

4307

ST313

1204

4444

1204

212-12

Purchased

No

110

Each

158.0000

9

**

DAS
27
9-89

DAS
26
9-89

212-12

Receptacles

DAS
18
9-89

Location

Loc Qty

Loc Code

ST566

82

M128818

82

ST567

1

M129706

1

ST568

75

M131959

75

2600-6

Purchased

No

110

Each

188.0000

9

9

**

DAS
27
9-89

DAS
26
9-89

2600-6

Camlock Stud

DAS
18
9-89

Location

Loc Qty

Loc Code

ST569

188

M128398

4

M129790

100

M131296

2

M131959

82

JUN 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Thursday, April 16, 2015 9:16:37 AM

Page 2

Work Order ID: 131582

Parent Item: D350-567-023

Parent Item Name: Replacement Window

131582

D350-567-023

Start Date: 4/16/2015

Required Date: 4/16/2015

Start Qty: 1.00

Required Qty: 1.00

2600-LW

Purchased

No

110

Each

371.0000

9

9

2600-LW

Washer, Camlock Retaining

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST569

366

m131296

66

m131959

300

ST570

5

m128429

5

110

Each

479.0000

22

22

AN526C832R9

Purchased

No

AN526C832R9

Screw

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST325A

450

M131624

200

M131957

250

ST327

29

M129391

29

110

f

703.5468

7

7

D2463

Manufactured

No

D2463

172" Seal (\$Per Foot)

**

DAS
27
JUN 27 2015

DAS
26
9-89

Location

Loc Qty

Loc Code

ST409

39.9568421

115701

39.9568421

ST638

663.59

125469

663.59

(D2463-075) Cut (1) at 75.00" as per dwg ***per kit***

Thursday, April 16, 2015 9:16:37 AM

Shop Packet Print

Page 2

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Parent Item: D350-567-023

Parent Item Name: Replacement Window

131582

D350-567-023

Start Date: 4/16/2015

Required Date: 4/16/2015

Start Qty: 1.00

Required Qty: 1.00

D2942 Manufactured No

110 Each

5.0000

**

1

DAS
27
9-89

DAS
26
9-89

D2942

Replacement Window 4:05-025

DAS
8
9-89

Location

Loc Qty

Loc Code

ST430

5

97912

5

110 Each

0.0000

**

1

DAS
27
9-89

DAS
26
9-89

DT8439 Manufactured No

110 Each

0.0000

**

1

DT8439

TEMPLATE

FG-778150-550-ROL

DAS
8
9-89

Purchased No

110 sf

1,105.000

**

18

DAS
27
9-89

DAS
26
9-89

FG-778150-550-ROL

7781 9oz Glass 50x125yd

DAS
8
9-89

Location

Loc Qty

Loc Code

CA2

1105

M127701

1105

110 Each

1,560.000

**

22

DAS
27
9-89

DAS
26
9-89

2 Square Yards

MS21042L08

Purchased No

MS21042L08

Nut

DAS
8
9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

1000

m131697

1000

ST304

459

123900

16

m128401

102

m130325

15

m131317

296

m131624

30

JUN 22 2015

Thursday, April 16, 2015 9:16:37 AM

Shop Packet Print

Page 3

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Description Work Order Deviation				Disposition				Completed By																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

Picklist Print

Thursday, April 16, 2015 9:16:37 AM

Work Order ID: 131582

Parent Item: D350-567-023

Parent Item Name: Replacement Window

131582

D350-567-023

Start Date: 4/16/2015

Required Date: 4/16/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

110

Each

2,808.000

44

44

**

DAS

27

9-89

JUN 22 2015

DAS

26

9-89

NAS1149DN832.I

Washer

Location

Loc Qty

Loc Code

CA

84

M129499

84

MF4

185

M129541

185

ST260a

2452

M131697

2452

ST270

87

124555

15

M131317

72

DAS

6

9-89

Thursday, April 16, 2015 9:16:38 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Ref

DAS
6
9-89

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

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Date: 13.08.15